

Monday, October 24, 2016 11:41:30 AM

152453

Page 1

N900040100

Setup Start *NS1*

Stop *NS2*

6

Cust Item ID:

6

Customer:

Reference:

Approvals: Process Plan: Date:
QC: Date:

Tooling: _____ **Date:** _____

SPC (Y/N): _____ **Date:** _____

Run	Start	*NR1*
	Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2432	H								

0.00

120

FLOW WATER JET

Waterjet

Memo

0.15

FLOW CNC Waterjet

Cut Blank as per D2432 File

0.09

130

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.45

HAAS CNC vertical machine #1

- 1-Inspect material for defects or damage prior to machining
- 2-Machine as per Folio and Dwg D2432 Identify as D2432F
- 3-Deburr

0.00

140

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.01

Quality Control

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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Work Order ID 152453

Monday, October 24, 2016 11:41:30 AM

152453

Page 2

Item ID: D2432 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Bearpaw 19" X 24"
Start Date: 10/7/2016 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 10/24/2016 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC8- Inspect parts - second check	0.00							
150									
QC	Memo	0.02							
Quality Control									
160	Identify as per dwg & Stock Location: <u>St</u>	0.00							
160									
Packaging	Memo	0.01							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.10							
Quality Control									

NOV 0 8 2016

16-11-8

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Picklist Print

Monday, October 24, 2016 11:41:29 AM

Page 1

Work Order ID: 152453

152453

Parent Item: D2432

D2432

Parent Item Name: Bearpaw 19" X 24"

Start Date: 10/7/2016

Required Date: 10/24/2016

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A 12.10.17 AS PER DWG REV.H DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No			120	sf	454.0000	3.7	22.2			

MUHMWB10

UHMW 1" Black - 48"x120" Tivar Mfg.#52480104

OK 10/27

Location

Loc Qty

Loc Code

MAT

40

m135497

40

23

MAT018

414

m135013

14

m135913

400

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				

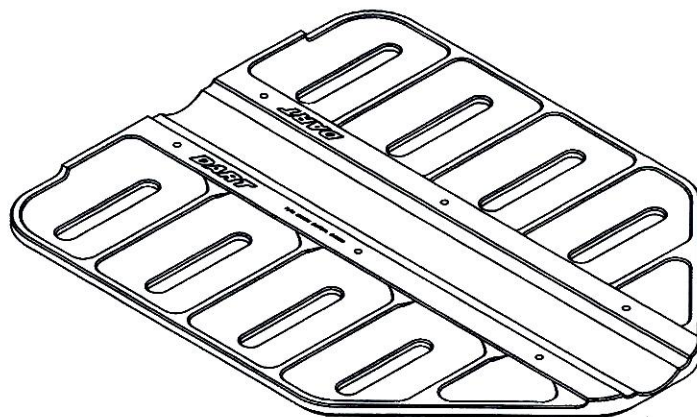
DART AEROSPACE LTD		Work Order:	152453
Description: Bearpaw		Part Number:	D2432
Inspection Dwg: D2432 Rev: H		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

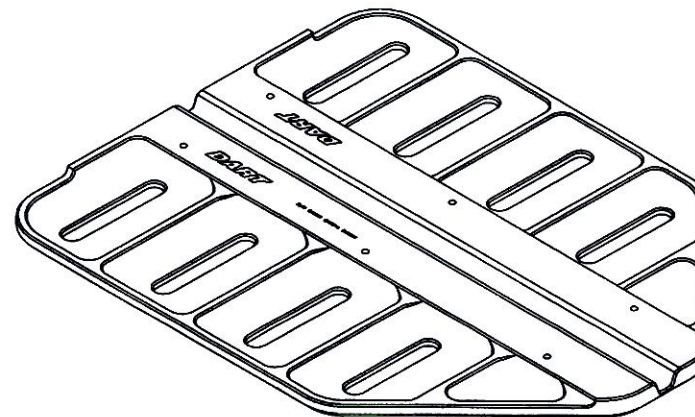
Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.057	✓		depth	OK-07
B	0.200	+/-0.030	0.198	✓		depth	OK-08
C	0.25 x 45°	+/-0.030	0.275	✓		"	OK-07
D	R0.250	+/-0.030	0.250	✓		rad G	Shop
E	0.250	+/-0.010	0.247	✓		cal	OK-01
F	0.625	+/-0.030	0.621	✓		"	"
G	0.375	+0.030/-0.010	0.390	✓		"	"
H	0.950	+/-0.030	0.957	✓		"	"
I	19.000	+/-0.030	19.000	✓		tape	Shop
J	Ø0.260	+0.005/-0.000	0.260	✓		cal	OK-01
K	Ø0.93	+/-0.030	0.930	✓		"	"
L	0.30	+0.030/-0.000	0.310	✓		depth	OK-08
M	23.750	+/-0.030	23.750	✓		tape	Shop
N	2.000	+/-0.030	2.000	✓		cal	OK-01
O	0.38	+/-0.030	0.379	✓		"	"
P							
Q							
R							
S							
T							
U							
V							

Measured by:	DAS 45 9-89	Audited by:	Y. DAS 08 9-89	Preliminary Approval:	
Date:	2016-11-04	Date:	16/11/07	Date:	

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue P/O D206-559-015	KJ/RF	
B	12.07.31	Dwg Rev updated	KJ	
C	12.10.26	Dwg Rev updated	KJ	
D	13.07.18	Dimension 7.375 removed	KJ	
E	15.02.09	Dimensions revised	KJ	



D2432F BEARPAW

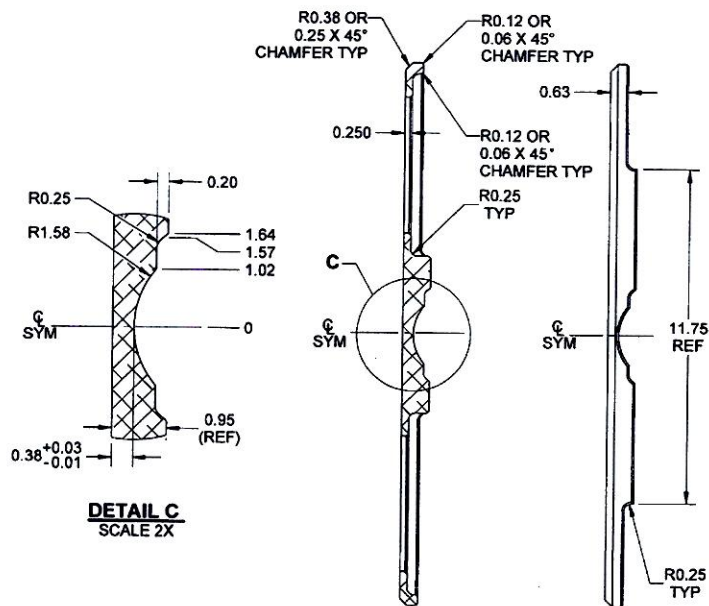


D2432-3 BEARPAW

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 152453 MLO
161024

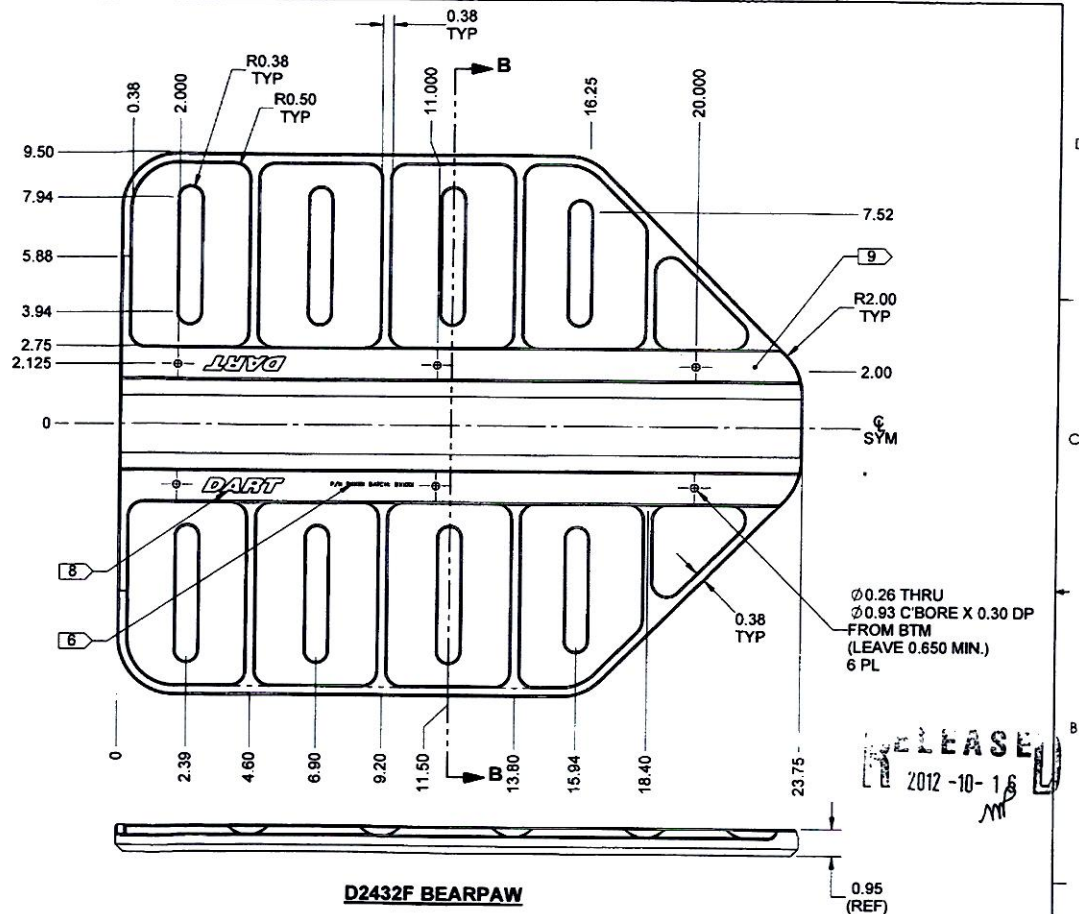
RELEASED
2012-10-16

H	RIB HEIGHTS CHANGED TO CONDITION OF REV. F. SEE REV. F FOR DETAILS.	AP	12.09.24		
G	UPDATE DRAWING FORMAT, REMOVED D2432B, ADD D2432-3, ADDED DIMENSION 7.52 (D1-2)	AP	12.05.02		
F	CHANGE C'BORE, ADD B AND F P/N	-	98.05.12		
E	CHANGE C'BORE DEPTH, BORE RADIUS	-	97.02.27		
D	MOVE SLOT	-	96.06.04		
C	CHANGE BORE AND C'BORE DEPTH	-	96.03.25		
B	RE-DESIGN	-	96.01.24		
A	NEW ISSUE	-	95.10.31		
REV.	DESCRIPTION	BY	DATE		
DESIGN	LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN	AP				
CHECKED	AS			DRAWING NO.	REV.
MFG. APPR.	ST			D2432	SHEET 1 OF 3
APPROVED	AD			TITLE	SCALE
DE APPR.	ST	BEARPAW	NT		
DATE	12.09.24	COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPERTY AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			



DETAIL C
SCALE 2X

SECTION B-B



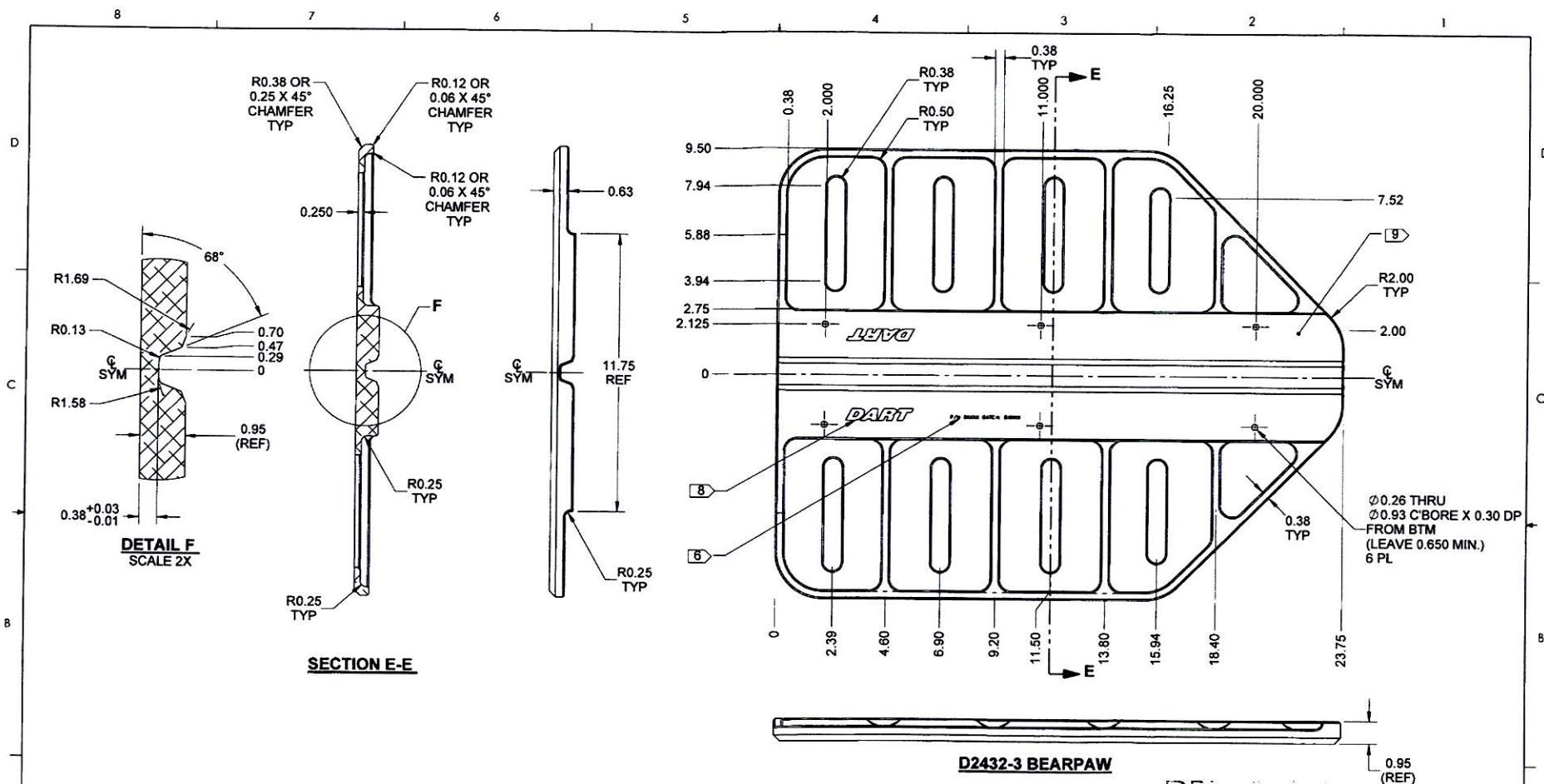
D2432F BEARPAW

NOTES:

- 1) MATERIAL: UHMW BLACK TIVAR 1000 VIRGIN MATERIAL, 1.000 THICK MACHINED TO 0.950 (REF DART SPEC. MUHMWB10)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER "D2432" AND BATCH NUMBER "BXXXXX" IN ACCORDANCE WITH QSI 044 METHOD 6.3
- 7) WEIGHT: 5.87 lbs
- 8) ENGRAVE DART LOGO TO MAX DEPTH OF 0.012
- 9) APPLY 0.06 x 45° CHAMFER TO ALL EDGES ON SIDE SHOWN UNLESS OTHERWISE INDICATED
- 10) PROFILE PER DRAWING FILE "D2434F-REVH.STP"

DESIGN	LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	ALS	DRAWING NO.	REV. H
MFG. APPR.	AP	D2432	SHEET 2 OF 3
APPROVED	AP	TITLE	SCALE
DE APPR.	AP	BEARPAW	NTS
DATE	12.09.24	COPYRIGHT © 1985 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMBOD OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASE
2012-10-16
M



RELEASED
2012-10-16

DESIGN	LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	ALS	DRAWING NO.	REV. H
MFG. APPR.	at	D2432	SHEET 3 OF 3
APPROVED	at	TITLE	SCALE
DE APPR.	at	BEARPAW	NTS
DATE	12.09.24	COPYRIGHT © 1998 BY DART AEROSPACE LTD THIS DOCUMENT IS RELEASED AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

